

Work Order ID 47002B

September 11, 2009 8:40:07 AM

Page 1

Item ID: D3186-4

Accept

Revision ID: D

Item Name: Spacepod Door, RH

Start Date: 9/11/09 Start Qty: 1.00

Required Date: 9/11/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3186

Rev D

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

120

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

Picklist Print

September 11, 2009 8:40:06 AM

Page 1

Work Order ID: 47002B



Parent Item: D3186-4RevD



Parent Item Name: Spacepod Door, RH

Start Date: 9/11/09

Required Date: 9/11/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3186-2MRevD		Manufactured	No			100	Each	2.0000	1.0000			
SPACEPOD DOOR RH												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

CA

2

47002B01

1

48150C01

1

D350-600-242

Dart Aerospace Ltd.

Date: Tuesday, 07/04/2009 10:28:22 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR RH
Job Number	: 47002B		
Estimate Number	: 12636		
P.O. Number	:	Part Number	: D31864
This Issue	: 07/04/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3186 REV.D
First Issue	: / /	Project Number	: N/A
Previous Run	: 46180B	Drawing Revision	: D
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 10/05/2009
Checked & Approved By	: <u>JUD 09.04.07</u>	Qty:	1 Um: Each
Comment	: Est Rev.A New Issue 07-01-11 EC est rev.B revD 07.03.07 ec		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

47002B01

SPACEPOD DOOR RH



Comment: Sub-Component SPACEPOD DOOR RH
 1 x D3186-2M Batch 47002B01

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Ph

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)

IT 09-08-31

3.0

QC5

INSPECT WORK TO CURRENT STEP

**Comment:** INSPECT WORK TO CURRENT STEP

S 02/09/01

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

45540

U 09.09.11

5.0

QC21

FINAL INSPECTION/W/O RELEASE

**Comment:** FINAL INSPECTION/W/O RELEASE

09/09/11

Job Completion



U 09.09.11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.09.01	Z	CUT SLOTS 1.10 FROM EDGE INSTEAD OF 0.98	BT 0908 -31			GP 09.09.01 08/04/2	S 08/08/01	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

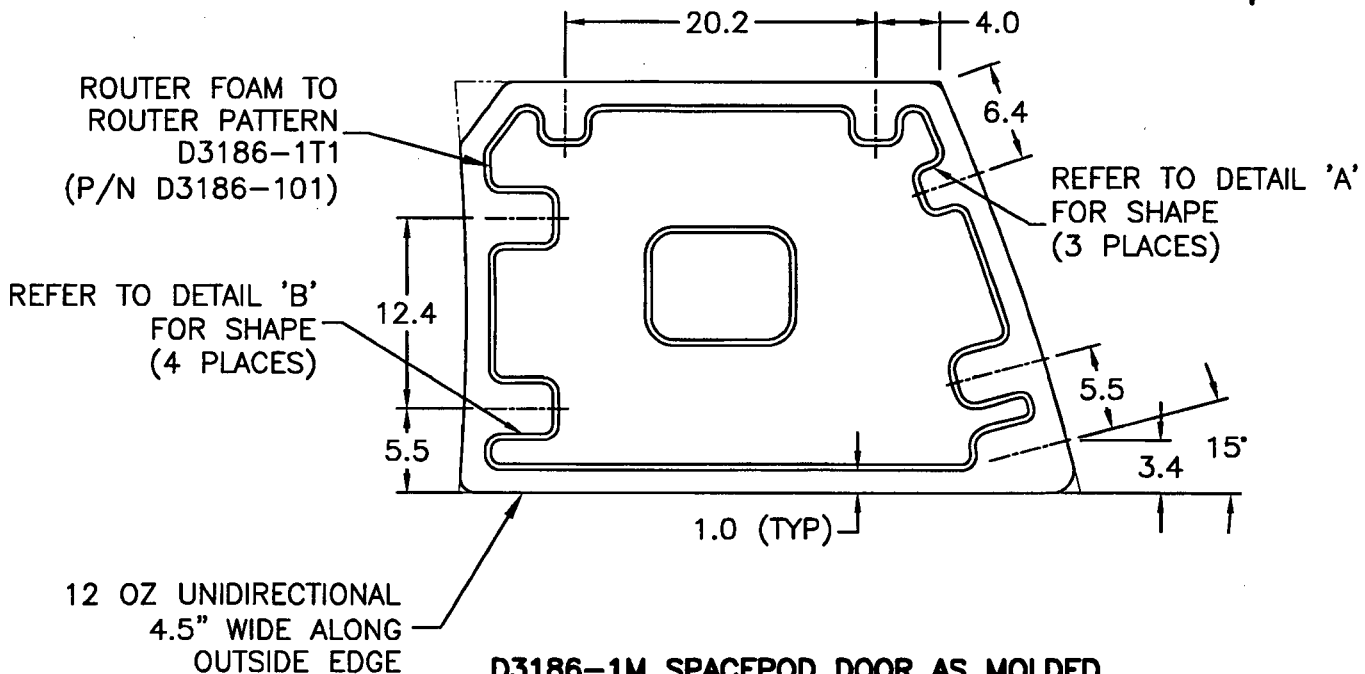
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CHECKED B	APPROVED H	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27

**D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DATE 07.02.27

BY 17002B

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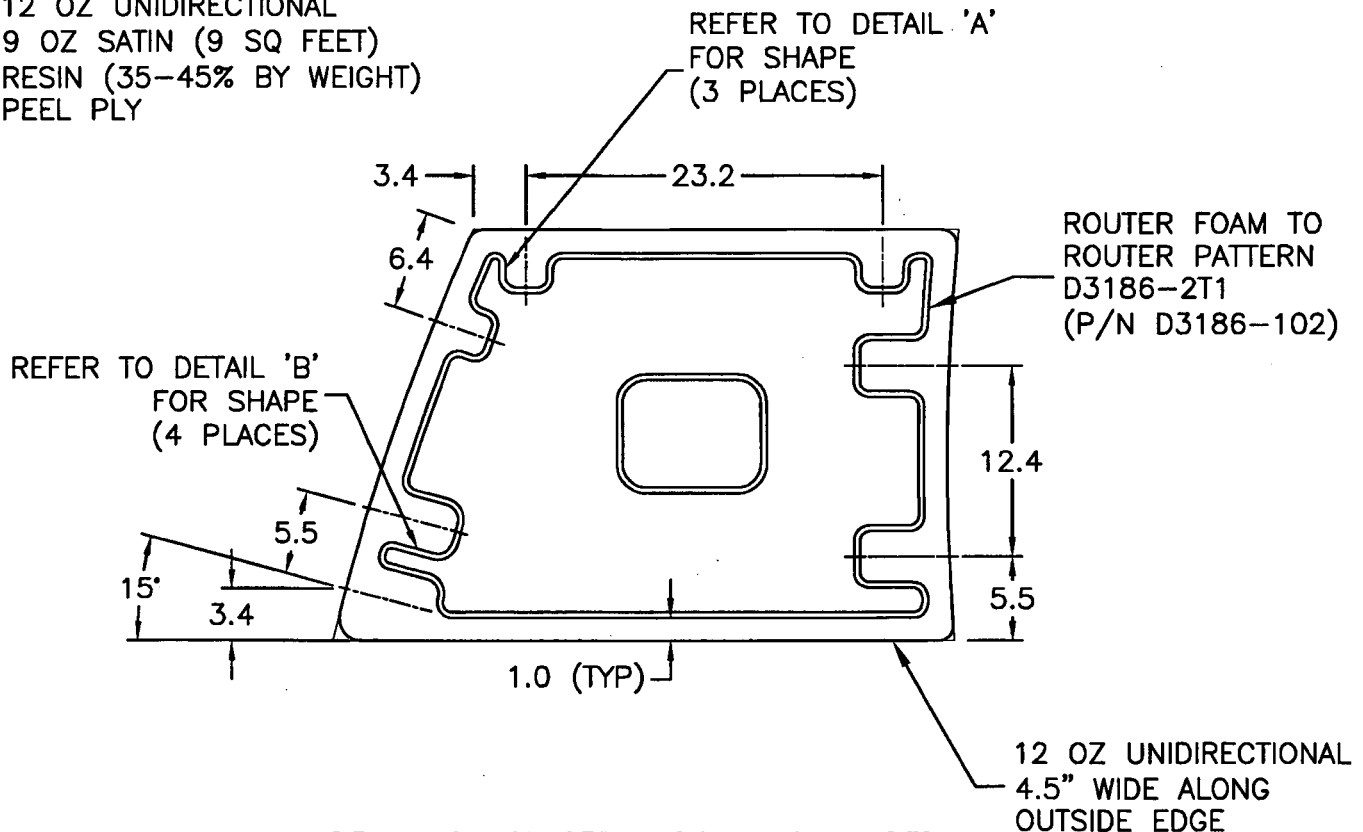
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 H

**D31P6-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
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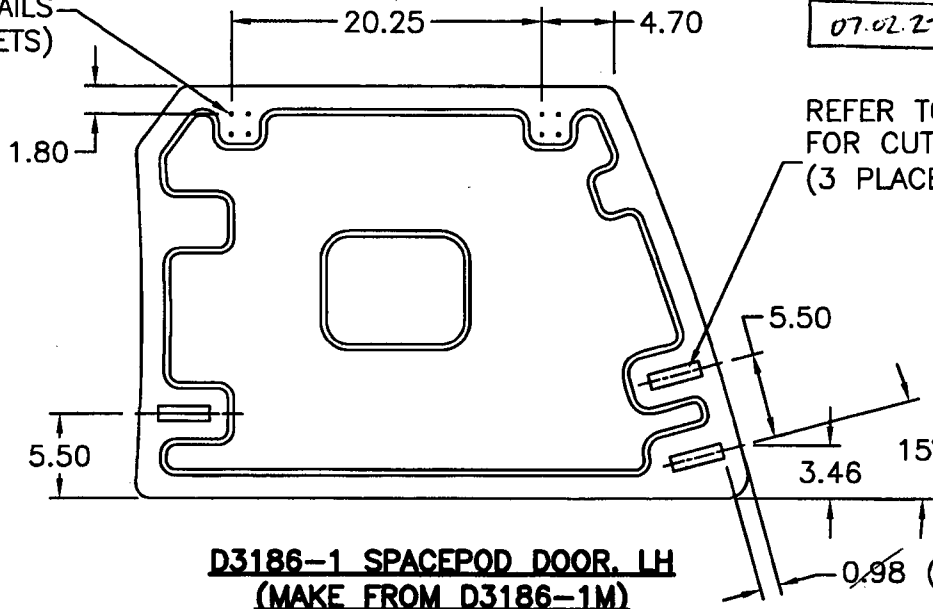
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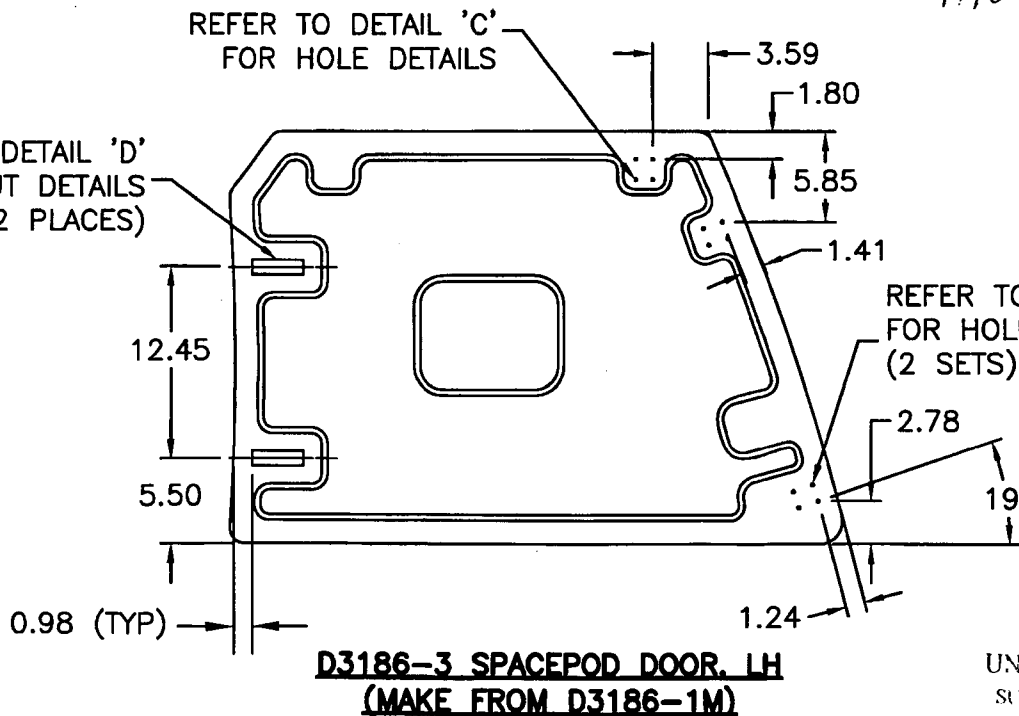


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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)



REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(2 PLACES)



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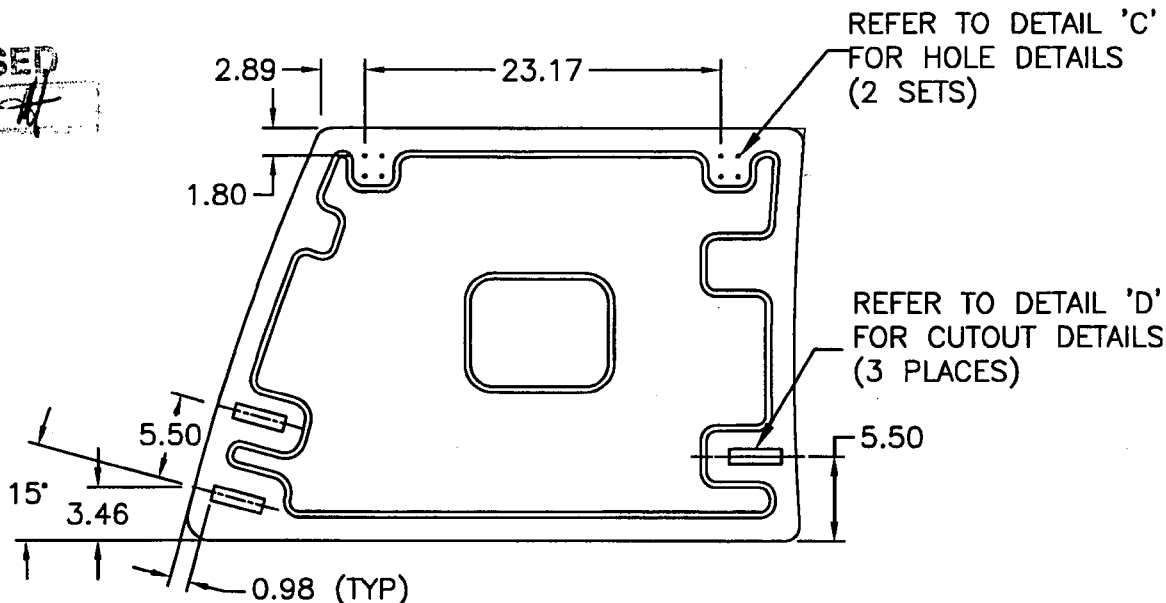
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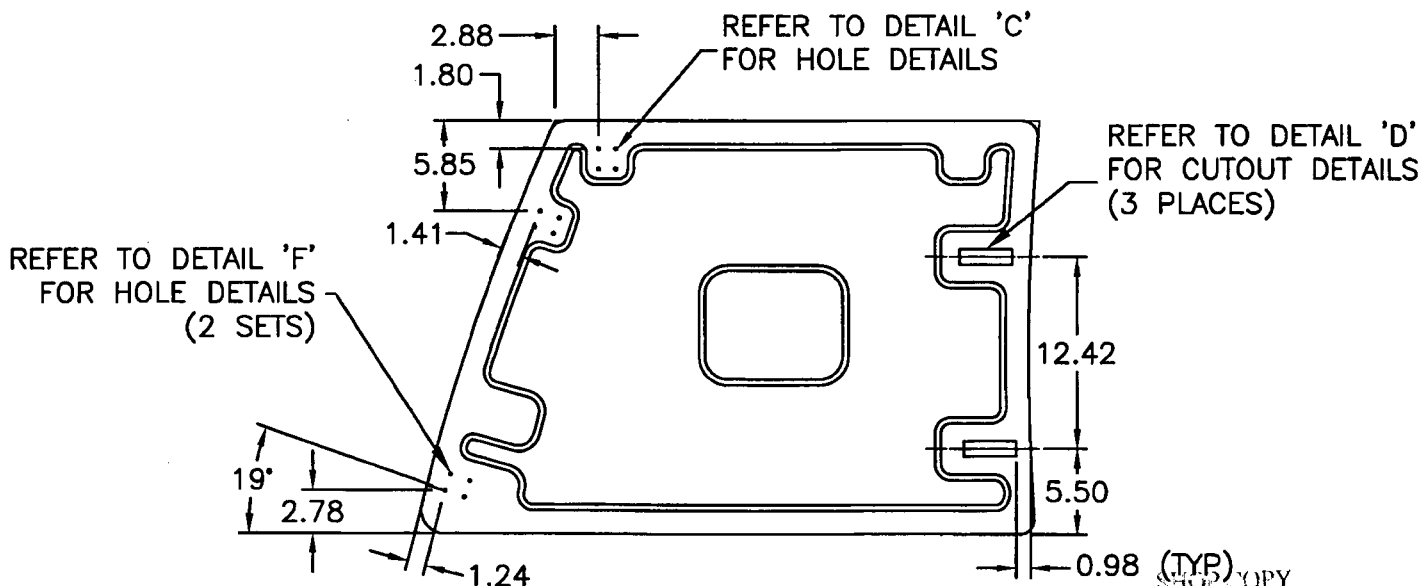
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DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED

07-02-27



D3186-2 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR. RH
(MAKE FROM D3186-2M)

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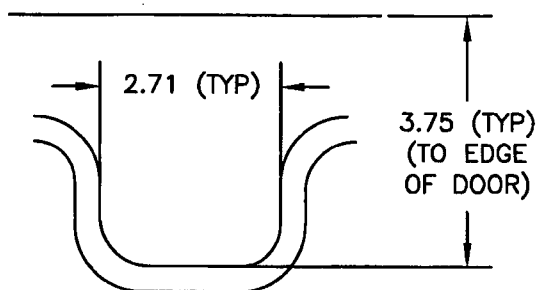
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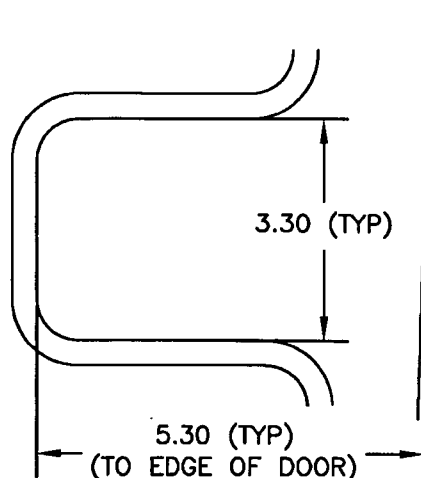
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DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS



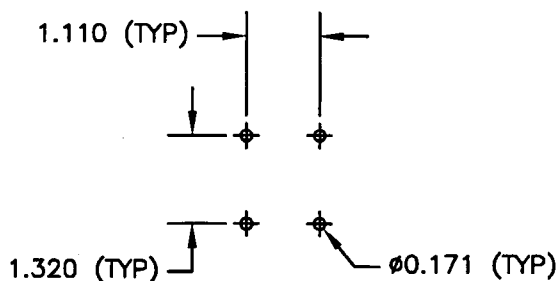
DETAIL A



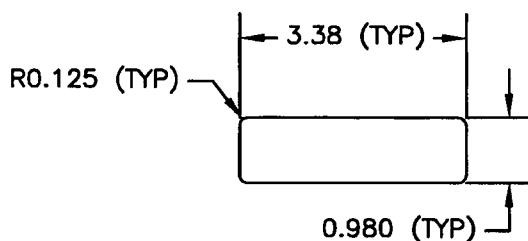
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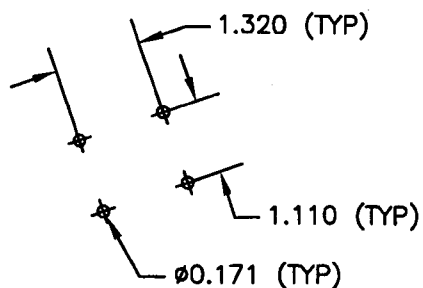


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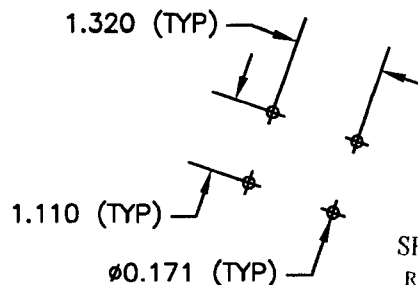


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

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